

Date: Friday, 18/07/2008 10:50:38 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HEATER TUBE 6"		
Job Number	: 40622		Part Number	: D2293		
Estimate Number	: 12699		Drawing Number	: D2293 REV. B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 18/07/2008	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: SMALL /MED FAB			
Previous Run	: 31185		Due Date	: 10/08/2008		Qty: 8 Um: Each
Written By	:					
Checked & Approved By	: JUD 08.7.08					
Comment	: Est Rev:A New Issue 07-02-02					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T6000W250	6061-T6 RD Tube 6.00 X .250W
Comment: Qty.: 0.0875 f(s)/Unit Total : 0.6997 f(s) 6061-T6 Tube 6.00x.250W Material: 6061-T6 (6" OD x 0.250") wall seamless tubing (M6061T6T6.000W.250) Batch: M103436 <i>MNF 08/07/08</i>		
2.0	LATHE CONV.	CONVENTIONAL LATHE
Comment: CONVENTIONAL LATHE TURN I.D AS PER DWG D2292 <i>JF / MNF 08/07/08</i> ⑧ 10		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>JF MNF 08/07/08</i> ⑧		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>10 08/07/08</i> ⑧		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>8/122 C-877/22 ⑧</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2293 PAR #: 2/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: D Date: 08/07/21
 QA: N/C Closed: D Date: 08/07/21

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/21	2.0	two parts scrap. - one part 1.000" Dim is 0.977" - one part wall thickness is 0.125" → .106" instead of 0.125" R.C. one step Dremel machining - operator didn't measure correctly.	J 08/07/21	Scrap and Destroy and Replace Qty x2 B# 103430	MMF 08/07/21	S 08/07/21	J 08/07/21	S 08/07/21
					MMF 08/07/21	S 08/07/21		

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40422
Description: Heater Tube 6"	Part Number:	D2293
Inspection Dwg: D2293	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

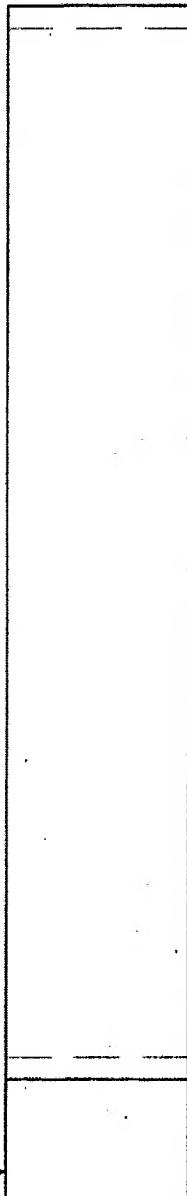
X First Article Prototype

Measured by: <u>MMF</u>	Audited by: <u>PC</u>	Prototype Approval: N/A
Date: <u>08/01/22</u>	Date: <u>08/01/22</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.03.13	New Issue	KJ/JLM	<i>[Signature]</i>

DARTQA COPY AS
ISSUED

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED B.W.	APPROVED B.W.	DRAWING NO. D2293	REV. B SHEET 1 OF 1
DATE 94.10.25		TITLE 6" HEATER TUBE	SCALE 1:1
	B	96.01.15	CHANGED MATERIAL



1.000

SHOP COPY
RETURN TO
ENGINEERINGUNCONTROLLED COPY
SUBJECT TO AMENDMENTWITHOUT NOTICE
WORK ORDERNO. 40622MATERIAL: 6061-T6 TUBE
6" DIAM 0.125 WALL CUT 1" LONG